

Work Order ID 62964

Page 1

Thursday, October 14, 2010 12:40:16 PM

Item ID: D412-742-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 10/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: 

Date: 10-10-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D412-742	D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-011 CHG006

5

11 03 07 17
H for BG 11-02-28

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Purple 11

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

11 03 01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 62964

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Item ID: D412-742-011

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Start Date: 10/14/2010 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD412-742-011

Location: per C*C4/3/01*

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/03/01
C21103101

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 62964

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010


Start Qty: 1.00

Required Qty: 1.00


Comments:

IPP Rev: A 05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM
 IPP Rev: C 07-05-28 As per Rev C JLM
 IPP rev D 07.11.01 ecn 1053P EC
 IPP rev E 07.11.27 ecn 1072 EC verified by: DD
 IPP Rev: F 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: G 09-01-23 as per DSI9441 DD verified by: EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21043-3  Nut		Purchased	No			100	Each	2,564.000	33	33			
--	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--

Location	Loc Qty	Loc Code
FG	76	
103691	76	
ST301	2488	
111383	23	
112314	2465	

AN3C37A  BOLT		Purchased	No			110	Each	60.0000	3	3			
---	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST354	60	
114761	10	
114801	50	

AN3C40A  BOLT		Purchased	No			110	Each	112.0000	2	2			
---	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST354	112	
106176	12	
112454	50	
114442	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 62964

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

110.0000

3

3



BOLT



m116381 *CV*

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

106

108084

7

108409

8

114443

59

115316

32

AN3C42A

Purchased

No

110

Each

104.0000

3

3



BOLT



CV

Location

Loc Qty

Loc Code

ST354

104

106169

4

106176

100

AN3C43A

Purchased

No

110

Each

109.0000

3

3



BOLT



m106176

CV 11/2/28

Location

Loc Qty

Loc Code

ST354

109

114330

9

114433

50

114455

50

m114330 10
m114443 24

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Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C44A

Purchased

No

110

Each

128.0000

9

9



BOLT

Location

Loc Qty

Loc Code

ST355

128

106187

28

110848

100

110

Each

62.0000

10

AN3C47A

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST355

62

106171

13

110847

49

110

Each

75.0000

4

AN4C47A

Purchased

No



Bolt

Location

Loc Qty

Loc Code

ST361

75

115231

7

115358

8

115518

40

115836

20

110

Each

120.0000

8

8

AN4C52A

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST361

120

112641

50

113121

20

114784

50

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

S

 AN4C6A

 Bolt

 Purchased No 110 Each 319.0000 16 16

 M116003

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST	4	
103344	0	
111295	4	
ST356	311	
113121	111	
115016	200	

S

 AN4C7A

 Bolt

 Purchased No 110 Each 452.0000 4 4

Location	Loc Qty	Loc Code
ST356	452	
109147	452	

S

 AN6C12A

 BOLT

 Purchased No 110 Each 48.0000 8 8

 109147

Location	Loc Qty	Loc Code
ST342	48	
114442	48	

S

 AN960C10L NAS1149C0332
 R
 washer

 Purchased No 110 Each 29.0000 66 66

 M114442
 M1182410

Location	Loc Qty	Loc Code
ST245	29	
107534	29	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62964

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C416L *WAS114960432R* Purchased

No

110

Each

180.0000

32

32



WASHER



11/6900

[Signature]

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

136

106785

10

107008

10

112828

75

69220

41

AN960C616L

Purchased

No

110

Each

156.0000

8

8



WASHER



[Signature]

Location

Loc Qty

Loc Code

ST347

156

113064

156

D2571

Manufactured

No

110

Each

15.0000

1

1



Saddle, Fwd Out 205



113064

62111

[Signature]

Location

Loc Qty

Loc Code

ST425

7

43564

3

47564

4

ST433

8

58250

3

61332

5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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* Picklist Print

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Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2572



Saddle, Fwd In 205

Manufactured No

110 Each

5.0000

1

1



62150 C

Location

Loc Qty

Loc Code

ST425

3

43565

3

ST433

2

60705

2

D2573



Saddle, Aft Out 205

Manufactured No

110 Each

10.0000

1

1



63501 C

Location

Loc Qty

Loc Code

ST425

7

43566

3

47566

4

ST434

3

60706

3

D2574



Saddle, Aft In 205

Manufactured No

110 Each

6.0000

1

1



62152 C 11/2/2010

Location

Loc Qty

Loc Code

ST425

3

43567

3

ST434

3

60707

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62964

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2747

Manufactured No

110 Each

145.0000

4

4



Set Screw

Location

Loc Qty

Loc Code

ST023

145

39224

4

59879

41

62085

100



62085

D2876

Manufactured No

110 Each

54.0000

2

2



Saddle Spacer

Location

Loc Qty

Loc Code

ST026

49

60853

49

ST028

5

51540

5



60853

D2877

Manufactured No

110 Each

65.0000

2

2



Saddle Spacer

Location

Loc Qty

Loc Code

ST026

65

60854

24

61211

41



61211

D3403-1

Manufactured No

110 Each

43.0000

16

16



Bushing

Location

Loc Qty

Loc Code

ST052

30

61654

30

ST055

13

59119

13



64773 110 6/11/2010

6165450

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 62964

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3403-3
Bushing

Manufactured No

110 Each

27.0000

8

8

Location

Loc Qty

Loc Code

ST053

25

59598

25

ST055

2

56857

2

D3405-041
Lug Assembly

Manufactured No

110 Each

8.0000

Location

Loc Qty

Loc Code

ST474

8

60495

8

D3405-043
Lug Assembly

Manufactured No

110 Each

2.0000

Location

Loc Qty

Loc Code

ST474

2

53888

1

56514

1

D3407-041
Tow Ring

Manufactured No

110 Each

13.0000

Location

Loc Qty

Loc Code

ST464

13

59632

2

61219

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 62964

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3417-3

Manufactured No

110

Each

108.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST056

108

44349

27

51648

28

53182

53

44349

D3456-1

Manufactured No

110

Each

17.0000

1

1



Washer

Location

Loc Qty

Loc Code

ST058

17

54692

17

64282

D3533-1

Manufactured No

110

Each

39.0000

2

2



Set Screw

Location

Loc Qty

Loc Code

ST069

39

51602

39

51602

D3672-11

Manufactured No

110

Each

856.0000

16

16



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

856

58046

856

58046

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 62964

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-3
Phenolic Washer

Manufactured No

110 Each

527.0000

32

32

Location

Loc Qty

Loc Code

ST077

527

47023

16

57704

511

D3672-9
Phenolic Washer

Manufactured No

110 Each

390.0000

8

8

Location

Loc Qty

Loc Code

ST077

390

35523

390

D412-742-015
Electric Step

Manufactured No

110 Each

0.0000

1

1

D412-742-041
Replacement Float Skidtube

Manufactured No

110 Each

0.0000

1

1

MS21043-4
Nut

Purchased No

110 Each

739.0000

29

29

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

699

112492

25

113069

8

114523

366

114784

300

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W/O:		WORK ORDER CHANGES					
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5.0 PARTS LIST

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

Item	Qty -011	Qty -041	Qty -015	Part Number	Description
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT
		1		D3391-041	412 FLOAT SKIDTUBE
1		*24		*AN3C4A	*BOLT
3		*12		*AN3C6A	*BOLT
4		*8		*AN3C7A	*BOLT
5		*44		*AN960C10L	*WASHER
6		*4		*MS27039C4-12	*SCREW
7A		*4		*D3672-3	*WASHER (REPLACES NAS1515H4L)
7B		*4		*AN960C416L	*WASHER
21A		*1		*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1		*D3566-1	*GASKET
22A		*1		*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1		*D3566-1	*GASKET
23A		*1		*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1		*D3566-5	*GASKET
10		*1		*D3391-011	*412 FORWARD TUBE
11		**1		**D3401-041	**TOW CAP
12A		**10		**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2		**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10		**AN3C4A	**BOLT
14A		**4		**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10		**AN960C10L	**WASHER
24A		**1		**D3564-13	**WEARSHOE
24B		**1		**D3566-13	**GASKET
20		*1		*D3391-013	*412 MID TUBE
28		**24		**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1		*D3391-015	*412 AFT TUBE
25A		**1		**D3537-1	**WEARPAD
25B		**1		**D3553-1	**GASKET
26A		**1		**D3537-7	**WEARPAD
26B		**1		**D3553-3	**GASKET
31		**1		**D2646	**AFT CAP
32		**14		**AELS-1032-130	**INSERT
36		**12		**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6		**AN3C4A	**BOLT
37B		**4		**AN3C5A	**BOLT
38A		**2		**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10		**AN960C10L	**WASHER
39		**4		**ALS4-428-165	**INSERT (REPLACES NAS1330S4KB151)

(CONTINUED ON PAGE 17)

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D412-742

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(CONTINUED FROM PAGE 16)

Item	Qty -011	Qty -041	Qty -015	Part Number	Description
40	1			D2571	SADDLE, FWD OUTSIDE
41	1			D2572	SADDLE, FWD INSIDE
42	1			D2573	SADDLE, AFT OUTSIDE
43	1			D2574	SADDLE, AFT INSIDE
44	2			D2876	SADDLE SPACER
45	2			D2877	SADDLE SPACER
46	16			D3403-1	BUSHING
47A	4			D2747	SET SCREW
47B	2			D3533-1	SET SCREW
48	16			AN4C6A	BOLT
49	8			AN4C52A	BOLT
50	8			AN6C12A	BOLT
51A	32			D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32			AN960C416L	WASHER
52A	8			D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8			AN960C616L	WASHER
53	16			D3672-11	WASHER (REPLACES NAS1515H7L)
54	24			MS21043-4	NUT
55	4			AN4C7A	BOLT
60	8			D3403-3	BUSHING
61	1			D3405-041	GHW LUG
62	1			D3405-043	GHW LUG
63	4			AN4C46A	BOLT
64	4			MS21043-4	NUT
70	1			D3407-041	TOW RING
71	2			D3417-3	WASHER
72	1			MS21043-4	NUT
73	1			D3456-1	WASHER
80			1	D2913	DOUBLER
81		***4		***ALS4-428-165	***INSERT (REPLACES NAS1329S4KB140)
82		***4		***AELS-1032-130	***INSERT (REPLACES NAS1330S3KB116)
83			2	MS21043-4	NUT
84			2	MS24693-C272	SCREW
85			1	MS35489-35	GROMMET
86			1	MS35489-93	GROMMET
87		***4		***MS27039C1-09	***SCREW
88		***4		***MS27039C4-08	***SCREW
89A		***4	2	***D3672-1	***WASHER (REPLACES NAS1515H3L)
89B		***4	2	***AN960C10L	***WASHER
90A		***4		***D3672-3	***WASHER (REPLACES NAS1515H4L)
90B		***4		***AN960C416L	***WASHER
91	3			AN3C37A	BOLT
92	2			AN3C40A	BOLT
93	3			AN3C41A	BOLT
94	3			AN3C42A	BOLT
95	3			AN3C43A	BOLT
96	9			AN3C44A	BOLT
98	10			AN3C47A	BOLT
99	66			AN960C10L	WASHER
100	33			MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-041 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED ABOVE ASSEMBLY

***DENOTES THAT PART IS INCLUDED WITH D3391-013

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Revision: D

Date: 07.10.04

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37

REF. EASA STC: EASA.IM.R.S.01126

REFERENCE ONLY

INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT
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WAS:

63	4			AN4C46A	BOLT
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5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4		AN4C47A	BOLT
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WAS:

63	4		AN4C46A	BOLT
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A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
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